

Date: Tuesday, 11/29/2005 5:05:19 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ASPIRATOR ASSEMBLY
Job Number	: 25014		
Estimate Number	: 10480		
P.O. Number	: <i>N/A</i>	Part Number	: D2410
This Issue	: 11/29/2005 S.O. No. : <i>N/A</i>	Drawing Number	: D2410 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/29/2005 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	:	Material	: <i>D/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 12/15/2005
Checked & Approved By	:	Qty:	<i>3</i> Um: Each
Comment	: Est:C 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :								
1.0	D2375308	Insulation 48'of 3"ID*1/								
Comment: Qty.: 0.8333 f(s)/Unit Total : 3.3332 f(s) Insulation 48'of 3"ID*1/ Pick: <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>10.6"</td><td>D2375-3-08</td><td>Insulation</td><td><i>B1810</i></td></tr> </table> <i>FF 06-10-30</i>			Qty	Part Number	Description	Batch	10.6"	D2375-3-08	Insulation	<i>B1810</i>
Qty	Part Number	Description	Batch							
10.6"	D2375-3-08	Insulation	<i>B1810</i>							
2.0	D2403	Outer Skin								
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Outer Skin Pick: <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>1</td><td>D2403</td><td>Outer Skin</td><td><i>B21844</i></td></tr> </table> <i>FF 06-10-30</i>			Qty	Part Number	Description	Batch	1	D2403	Outer Skin	<i>B21844</i>
Qty	Part Number	Description	Batch							
1	D2403	Outer Skin	<i>B21844</i>							
3.0	D2404	Perforate Sheet,0.125 Ho								
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Perforate Sheet,0.125 Ho Pick: <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> <tr> <td>1</td><td>D2404</td><td>Perforated Sheet</td><td><i>B21544 x 2 / B25063 x 1</i></td></tr> </table> <i>FF 06-10-30</i>			Qty	Part Number	Description	Batch	1	D2404	Perforated Sheet	<i>B21544 x 2 / B25063 x 1</i>
Qty	Part Number	Description	Batch							
1	D2404	Perforated Sheet	<i>B21544 x 2 / B25063 x 1</i>							
4.0	D2411	Valve support, 5052-H34								
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Valve support, 5052-H34 Pick: <table border="0"> <tr> <td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr> </table>			Qty	Part Number	Description	Batch				
Qty	Part Number	Description	Batch							

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR ASSEMBLY

Job Number: 25014

Part Number: D2410

Job Number:



Seq. #:	Machine Or Operation:	Description :
1	D2411	Valve Mtg Angle <u>B25000</u> FF 06-10-30 3

5.0 D2412 Insulation filter



Comment: Qty.: 0.7673 sf(s)/Unit Total: 3.0692 sf(s)

Insulation filter

Pick:

Qty	Part Number	Description	Batch
110.5si	D2412	Insulation Filter	<u>B17099</u> FF 06-10-30 3

6.0 D2413 Intake Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Intake Weldment

Pick:

Qty	Part Number	Description	Batch
1	D2413	Intake Assembly	<u>B26905</u> FF 06-10-30 3

7.0 D2414 Outlet Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Outlet Weldment

Pick:

Qty	Part Number	Description	Batch
1	D2414	Outlet Assembly	<u>B26906</u> FF 06-10-30 3

8.0 D2416 Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty	Part Number	Description	Batch
1	D2416	Mounting Angle	<u>B26907x2 / B21844x1</u>

9.0 D2417 Mounting angle, 1x.625x.



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting angle, 1x.625x.

Pick:

Qty	Part Number	Description	Batch
1	D2417	Mounting Angle	<u>B26908x2 / B21844x1</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 25014

Part Number: D2410

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 MS20470AD45 Rivet, Universal Head



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)
Rivet, Universal Head

Pick:

Qty Part Number Description
8 MS20470AD4-5 Rivet

Batch

B18461

FF 06-10-30
~~06-30~~

3

11.0 MS20600AD4W2 Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Rivet

Pick:

Qty Part Number Description
8 MS20600AD4W2 Rivet
(or CR9163-4-2)

Batch

M4747

FF 06-10-30

3

12.0 MS20600AD4W3 Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Cherry Rivets

Pick:

Qty Part Number Description
2 MS20600AD4W3 Rivet
(or CR9163-4-3)

Batch

M14393

FF 06-10-30

3

13.0 MS20600AD4W4 Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Rivets

Pick:

Qty Part Number Description
12 MS20600AD4W4 Rivet
(or CR9163-4-4)

Batch

M101649

FF 06-10-30

3

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1

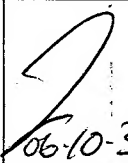


Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per Dwg D2410

FF 06-10-31
~~06-10-30~~

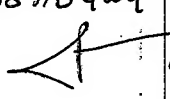
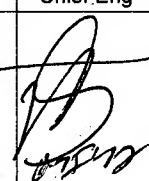

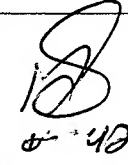
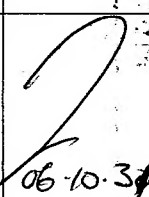
PTO

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		Create Dwg for Assembly					 06-10-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-10-31	14	7 extra ms 20600 AD4W4 		scraped (Pin pulled out out riveting) replace rivets.	FF 06-10-31	 06-10-31	 06-10-31	 06-10-31

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/08 (3)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3

****Place masking tape on red anodize tube of flare section and access to interior of both ends.****

FC 06 11 23 (3)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

SB 06/17/08 (3)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/12/08 (3)

19.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/12/11 (3)

Job Completion



U 06/12/11

W/O: _____		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	
A	95.04.06	NEW ISSUE	
A1	RF 03.04.29	ADDED FLARE	

RELEASED
9669/10 BW

QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS20600AD4W2	RIVET (CR 9163-4-2)
2	MS20600AD4W3	RIVET (CR 9163-4-3)
12	MS20600AD4W4	RIVET (CR 9163-4-4)
8	MS20470AD4.5	Rivets

DART

RELEASED
960910 803

PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED B.W.	APPROVED B.W.	D2410	REV. A
DATE Apr. 6, 1995	TITLE 206 ASPIRATOR ASSEMBLY	SHEET 2 OF 2	SCALE

